



Dart Aerospace Ltd.
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D135-1027-103
Job Sheet R205224



Part No: D135-1027-103

Job Qty: 1 pcs

Part Name: H135/EC135 - FWD Crosstube - Mid Height - w/ Saddles



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/6/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 1/20/20

Description: Per ECN19-841

Type: Rework

Note: IIN-D135-1027 REV.E IPP REV:A 17.10.24 NEW ISSUE DD VERF:JFS IPP REV:B 18.11.08 AS PER IIN REV.C DD VERF:JFS IPP REV:C 19.04.22 AS PER IIN REV.D DD VERF:JFS/IPP Rev.D 19.10.30 IIN update DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
111	Rework - 1 - Startup	1 pcs	1/20/20	1/20/20	0.00	1.00	Crosstubes - 1		JW 20/1/8
							Crosstubes - 2		
							Crosstubes - 3		
							Crosstubes - 4		
112	Rework - 2 - B4B	1 pcs	1/20/20	1/20/20	0.00	0.00	QC 5 - 10		g038
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
113	Rework - 3 - B4B	1 pcs	1/20/20	1/20/20	0.00	0.25	Spray Paint - 1 - B4B		DAS 41 JAN 11 2020
							Spray Paint - 2 - B4B		
							Spray Paint - 3 - B4B		
							Spray Paint - 4 - B4B		
114	Rework - 4 - B4B	1 pcs	1/20/20	1/20/20	0.00	0.00	QC 14 - 15		9-89
							QC 14 - 2		
							QC 14 - 34		



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Container No: S245664



Part: D135-1027-103

Job No: R205224

Serial No/Batch: S245664

Revision: E

Inspector:

Exp Date:

Instructions: TC STC SH18-49 Issue 1, FAA STC SR04276NY dated 18/11/21, E

Plex 1/6/20 9:20 AM Dart.Renwick.Jennifer

				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
130	Packaging 3-1 - Stock - B4B	1 pcs	1/20/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
135	DC - 1 - B4B	1 pcs	1/20/20	0.00 0.00	DC - 1 - B4B
					DC - 2 - B4B
140	QC 21 - FG	1 pcs	1/20/20	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53
Part Op 111 - 1-Pull D135-1027-103 from stock qty 1 batch number _____ 2-Drill extra holes as per ECN 19-841. Descriptions: ***Note*** Take extra care not to scratch spray paint. 3-Deburr blow out chips. 4-Touch up ALODINE. 112 - QC5- Inspect part completeness to step on W/O 113 - 1-Touch up spray as required see note 11. Paint-B _____ EXP. _____ Let cure as per QSI 005 2-Install D5739-1 plugs. Project 5227895 exp 3/00 114 - (QC14- Inspect Spray Paint)					

130 - Package as per PPP D135-1027-103 Identify and Stock Location :

135 - (Document Control) Photocopy blue file & type labels as per PPP D135-1027-103 CHG 002

140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D135-1027-103	H135/EC135 - FWD Crosstube - Mid Height - w/ Saddles	1 pcs (1 ea)	111-Rework - 1 - Startup	<u>5204201</u>
D5739-1	Plug	1 pcs (1 ea)	113-Rework - 3 - B4B	<u>5231642</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
111-Rework - 1 - Startup	D135-1027-103	1	3	0
113-Rework - 3 - B4B	D5739-1	1	1,000	0

Part Specifications

Specifications could not be found.

Plex 1/6/20 9:20 AM Dart.Renwick.Jennifer



Container No: S245664



Part: D135 - 1027 - 103

Job No: R205224

Serial No/Batch: S245664

Revision: E

Inspector:

Exp Date:

Instructions: TC STC SH18-49 Issue 1, FAA-TC SR04276NY dated 18/11/21, E

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ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date:	19.10.28	Job No.:	SE19-1027-02	ADR Yes/No:	Y	ADR Date:	19.09.10	ECN #:	19- 841
Product No.:	D135-1027			Created By:	MW	Approved By:	41		
Product Name:	Skid tubes			Checked By:	VO				

Reason for Change:

To introduce D135-1027-111/-113/-211/-213 Installations, revise crosstube drawings to include attachmet holes for OEM cargo hook
To revise IIN/ICA, To Add DSI 9834

Documents Released:

IIN-D135-1027 Rev. E, ICA-D135-10127 Rev. 2
D135-1027-141 Rev. C, D135-1027-143 Rev. C, D135-0127-151 Rev. E, D135-1027-163 Rev. C, D135-1027-241 Rev. C, D135-1027-243 Rev. D,
D135-1027-251 Rev. E, D135-1027-253 Rev. D
D5677 Rev. B, D5739 Rev. A
DSI 9834 Rev. A

IF APPLICABLE: NCR: PAR: CAR: CIR: URF: 19-841

PAPERWORK UPDATE



PARTS MUST COMPLY



PREVIOUS PARTS SATISFACTORY



#	Quality Assurance / Customer Support Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Airbus	N			
3	Notify Leonardo	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	Y	NO	URF 19-841 - Closed.	Completed 19.10.28
6	Update Master Document List (MDL)	Y	MW	MDL-D135-1027 Rev. D	Completed 19.10.28
7	Update Document Record (DR)	N			
8	Update Product Compatibility Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N	NO		
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	MG		Completed 19.10.28
12	Update Product Specification Files (Bluefiles)	Y	MG		Completed 19.10.28
13	Update Approved/Preliminary Dwg PDF Files	Y	MG		Completed 19.10.28
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	MG		Completed 19.10.28
17	Update / Verify Authorized Release Certificate Database	N			
18	Create / Update Change Record Form / Item Card Database	Y	MG		Completed 19.10.28
19	Create / Update Packaging Process Plan (PPP)	Y	MG		Completed 19.10.28
20	Red Decals required on Packaging Process Plan (PPP)?	Y	MG		Completed 19.10.28
21	Update Controlled Supplier Documents (Qpulse) Database	Y	MG		Completed 19.10.28
22	Update Grey Project Binder / Electronic Project Folder	Y	MG		Completed 19.10.28
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	Y	MG		Completed 19.10.28
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

Update Paperwork
Update BOMs and Routes
New Pick Kits D135-1027-111/-113/-211/-213 at CHG 001
Change D135-1027-101/-201/-103/-203 and D135-1027-141/-241/-143/-243 to CHG 002

ECN Verified & Complete: _____ Date: _____

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS								
		Rework ☐ Scrap ☐ Use-as-is ☐			Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected :		MRB (QSI042)									
Description Work Order Deviation		Disposition											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY											
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Other/Details:											
		Completed By											
		Lead hand / Supervisor											
		QC / QA Coordinator											